

Date Thursday, 16/08/2007 11:32:44 AM
 User Linda Lacelle

Process Sheet

split 1

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT
 Job Number : 34027
 Estimate Number : 12577
 P.C. Number : *N/A* Part Number : D3562042
 This Issue : 16/08/2007 S.O. No. : *N/A* Drawing Number : D3562 UNDER REVIEW
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : LARGE FAB ASSY Drawing Revision : A
 Previous Run : 33580 Material : *N/A*
 Written By : *[Signature]* Due Date : 09/09/2007 Qty: *4* Um: *5* Each
 Checked & Approved By : *[Signature]*
 Comment : Est Reva New Issue 06-11-09 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Qty Part # Description Batch:
 1 D2622-120C Extrusion *334016*

Check Material for any Dents or Defects

a.m 07.10.04 *(5)*

2.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:
 Qty Part Number Description Batch
 2 D2734 End Cap *334485*

[Signature] 07.10.04 *(5)*

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562 *a.m 07.10.04* *(5)*

2-Deburr and bevel ends for welding *a.m 07.10.04* *(5)*

3-Weld (1)end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod

4-Grind end cap welds flush as per Dwg D3562

Updated on 9/9/07 by RE

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 11:32:44 AM
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Drawing Name: STEP WELDMENT

Job Number: 34027

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Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

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|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

9/10/16

| | | |
|-----|-----|---------------------------|
| 5.0 | QC9 | VISUAL WELDING INSPECTION |
|-----|-----|---------------------------|



Comment: VISUAL WELDING INSPECTION

N/A

| | | |
|-----|-----------------|----------------------------|
| 6.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 02.10.04

5

| | | |
|-----|-----|---|
| 7.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|---|



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9/10/04

| | | |
|-----|----------|--------------|
| 8.0 | D3560042 | ARM WELDMENT |
|-----|----------|--------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

ARM WELDMENT

B 34475

9/07.10.12 (2)

| | | |
|-----|----------|--------------|
| 9.0 | D3560044 | ARM WELDMENT |
|-----|----------|--------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

ARM WELDMENT

Batch: B34477

9/07.10.12 (2)

| | | |
|------|--------------|-------------|
| 10.0 | MS20600AD4W5 | Blind Rivet |
|------|--------------|-------------|



Comment: Qty.: 36.0000 Each(s)/Unit Total: 180.0000 Each(s)

Blind Rivet

batch: M105125

9/07.10.12 (2)

| | | |
|------|-------------|-------------------------------|
| 11.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|------|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill Rivet holes as per dwg D3562.Touch up alodine.

a.m 02.10.12 (3) 9/07.10.12 (2)

P.T.O

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|--------------------|----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 01-10-11 | 1 | split w/o | He | 01-10-11 | 4 | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 11:32:44 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 34027

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description:

Rivet legs using Magnabond as per dwg D3562.
Ensure to wipe off any excess magnabond of the step

Q.M. 07.10.12 (3)

A/R Magnabond 6398

Batch: *M104677*

K 07.10.12 (2)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Charles on Helicopter



Comment: INSPECT WORK TO CURRENT STEP

07/10/16 (5)

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Remaining end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod *M103794*

07-10-16 5

2-Grind end cap welds flush as per Dwg D3562

Q.M. 07.10.16

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-10-16 (5)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/16 (5) (P12) →

16.0

POWDER COATING

POWDER COATING



M105068



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.K. 07/10/17

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: *M105694*

FL 07/10/18 (5)

PTO

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | |
|----------|------|---|-----------|----------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| 07-10-24 | #181 | Put bushing D2808 # <u>B32896</u> on steps | mf. EP | 07-10-24 | 5 | | | |
| 07/10/24 | #182 | ingred QC #5 | E | 07/10/24 | 5 | | En 07/10/24 | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/25
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|-----------------------------|---|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07/10/16 | # | During inspection a foreign object was found in the step after the CAPS were welded. | OS/042 | Drill small hole to insert cap to remove foreign object | 07-10-16 | En 07/10/16 | OS/042 | En 07/10/16 |
| | | | | Clear and remove debris | 07-10-16 | | | |
| | | | | Re weld hole as per drawing | 07-10-16 | | | |
| | | RC Human error | OS/042 | Re inspect bend QC #3 | PD 07-10-16 | En 07/10/16 | OS/042 | En 07/10/16 |
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Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-10-24

(17) See Previous Page

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

MF 7/10/24 (5)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(5) 07/10/24

Job Completion



U 07-10-24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

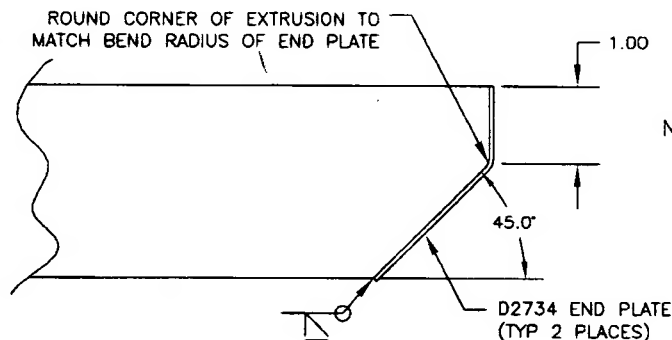
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

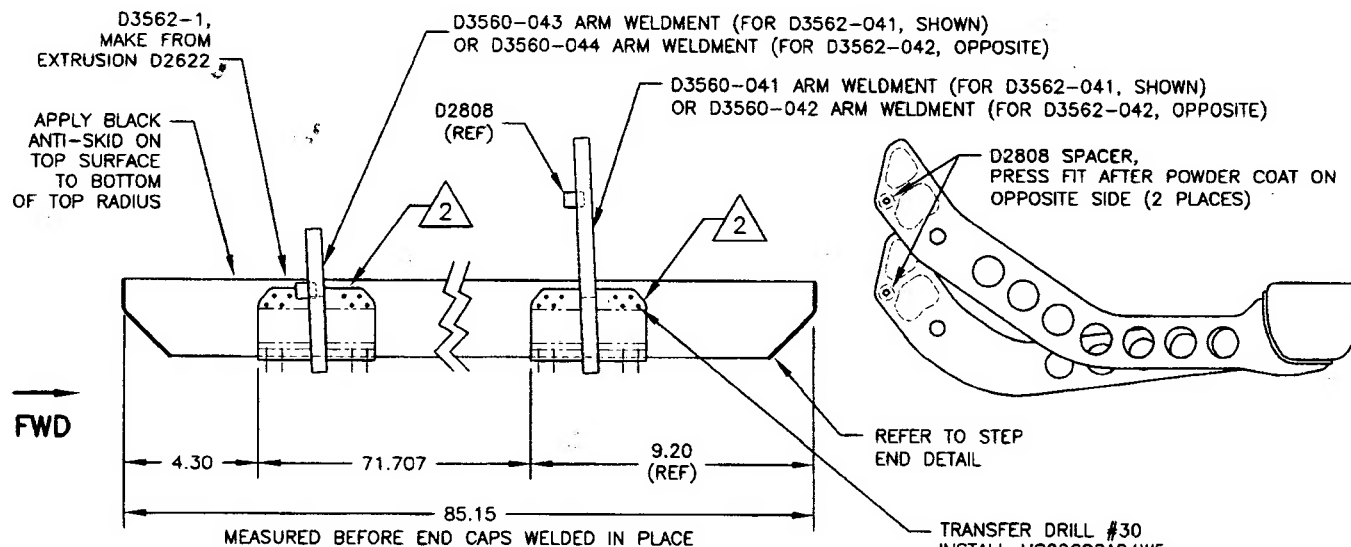
DART

RELEASED
07.06.21-11

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
NOT TO SCALE



D3562-041 LH STEP ASSEMBLY (SHOWN)
D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
|----------|----------|---|--------------|--|
| CHECKED | APPROVED | DRAWING NO. | REV. C | |
| DATE | | TITLE | SHEET 1 OF 1 | |
| 07.06.19 | | STEP ASSEMBLY | NTS | |
| A | 06.09.26 | NEW ISSUE | | |
| B | 07.01.15 | ARMS NOW RIVETED TO STEP | | |
| C | 07.06.19 | NOW MAGBND, ADD D2808, RMV 4 RVTS | | |

4/0 34027